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E C LOW VOLTAGE DIRECTIVE 73/23/EEC
E C ELECTROMAGNETIC COMPATIBILITY DIRECTIVE 89/336/EEC

DECLARATION OF CONFORMITY

We hereby certify that OSAKI MINI-MAX 125 Inverter Welder
Complies with all the relevant provisions of the
EC Directives 73/23/EEC & 89/336/EEC

Harmonised Standards Applied:
EN60974-1 + A1(2000) + A2(2003)
EN50199

Official Agent
KENNEDY TOOLS
Wigston Works, Leicester, England.
ISO 9002 REGISTERED COMPANY

CE 04

Signed: Martin Cooke

Date: 1st October 1999 **Name:** Martin Cooke **Position:** Director, The Kennedy Group Ltd.

QUALITY GUARANTEE & WARRANTY

OSAKI POWER TOOLS carry one years manufacturers warranty.

OSAKI POWER TOOLS are designed & produced to the highest standards & specifications

OSAKI POWER TOOLS are fully guaranteed against faulty materials & workmanship

Should they be found to be defective, they will either be repaired or replaced free of charge (fair wear and tear and/or misuse excepted).

Please retain supplier invoice as proof of purchase.

AVAILABLE FROM YOUR DISTRIBUTOR

© The Kennedy Group Ltd. 09/06

OSAKI POWER TOOLS

MINI-MAX 125 INVERTER

ORDER CODE
OSA-279-2000K

TÜV PRODUCT SERVICE GS

emc EUR

CE 99

OPERATORS MANUAL

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SAFETY INSTRUCTIONS

Osaki Power Tools are committed to the Production of Quality Power Tools
that are designed for high performance and long service life.
If safety and maintenance procedures are observed they will last for many years.

"Man, Earth and the Universe are forces that create an immovable centre of balance . . . OSAKI POWER TOOLS the balance of power"

Thank you for choosing our welder! In order to make the most of your equipment, please read the following very carefully:

The MINI-MAX 5mm is a portable, mono phase, air cooled direct current (DC) Inverter welder, for electrode welding MMA using all types of electrodes: rutile, basic, stainless steel, etc.

GENERAL SAFETY

- Keep work area clean - clutter invites injury.
- Do not expose the inverter welder to rain or damp conditions. Ensure work area is well lit. Do not use near flammable liquids or gases.
- Do not let people who are not familiar with the equipment handle it without supervision.
- Store in a dry, secure place, away from children.
- Use the correct tool for the job. The job will be done more efficiently and safely if the tool is used for it's intended purpose.
- Always wear welders gauntlets/leather gloves, a leather/fireproof apron and non-slip footwear.
- Always wear the welding mask provided or other propriety protection that includes a protective clear glass placed in front of a filtering glass.
- Always run the power cable away from the back of the welder to guard it from damage.
- When working outdoors only use suitably approved extension cables with a minimum conductor cross section of 1.5mm². The plug connectors must have earthing contacts and be waterproof.
- Secure work with a clamp or vice. This will allow both hands free to carry out the work.
- Disconnect from the power source when not in use, or when changing accessories/electrodes.
- Before using the welder, ensure that all parts are functional. A damaged part should be repaired and serviced by an authorised technician.
- Stay alert at all times. Watch what you are doing and use your common sense. Do not operate when you are tired.
- Do not store the machine in locations where the temperature may reach or exceed 50ºC (122ºF).

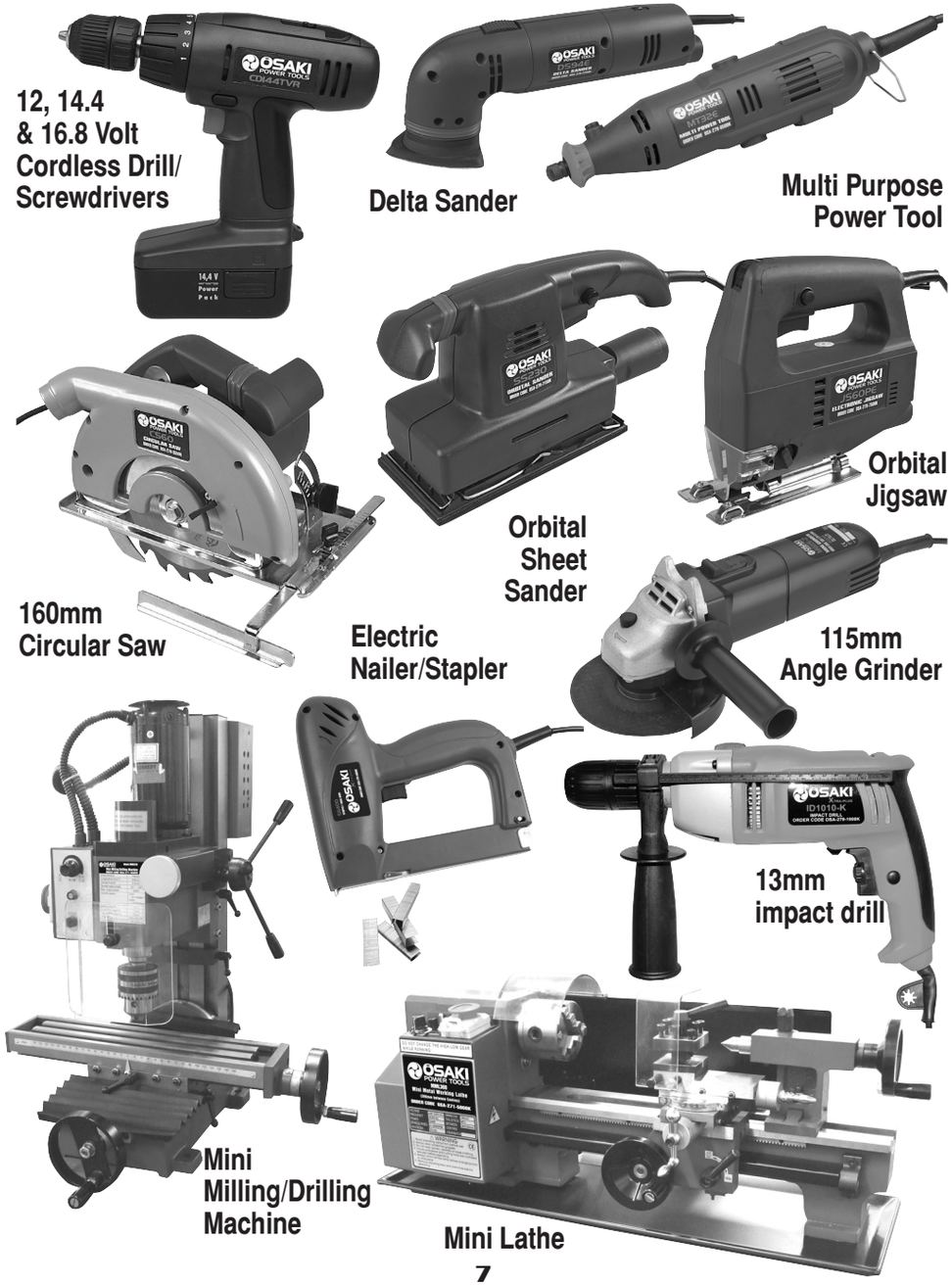
IMPORTANT

You must ensure that your inverter is connected to the power source via an earthed plug/wire. If not, you are at high risk of personal electrocution.

You must take precautions to protect yourself and others from:

- Smoke/fumes, fire and burns
- Arc radiance
- Rain, water, steam and humidity
- Electric shock
- Inflammable environment/elements

ALSO AVAILABLE FROM OSAKI



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SERVICE & REPAIR

A comprehensive in house repair and service facility is available through your local agent.

ACCESSORIES/CONSUMABLES

OSAKI POWER TOOLS recommends using KENNEDY welding rods available from your nearest Osaki Distribtuor.

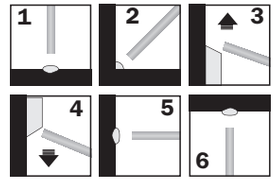
KENNEDY QUALITY INDUSTRIAL TOOLING

Electrodes for Mild Steels

Arc welding rods for mild steel and medium tensile steels.
Medium rutile coated, all positional rods*.
Applications: for steel plate and strip including structural steels and pipe work, especially under site conditions.
Superb finish with self-releasing slag.
N.B. Suitable for AC (50V minimum open circuit) and DC +/-.

Order Code KEN-891	Size (mm)	No of Rods (per pack)	Weight (per pack)	Minimum Amperage	Maximum Amperage
-3010K	2.50 x 300	260	5.0kg	50A	90A
-3020K	3.25 x 350	150	5.0kg	80A	125A
-3030K	4.00 x 450	100	5.0kg	120A	180A

* 1. Flat or Downhand position
2. Fillet welding in the horizontal vertical position
3. Butt and fillet welding in the vertical up position
4. Butt and fillet welding using the vertical down technique
5. Butt welding in the horizontal position
6. Butt and fillet welding in the overhead position



PACEMAKER/DEFIBRILLATORS

All staff/personnel with a pacemaker/defibrillator fitted must be aware that the electromagnetic energy generated when arc welding may cause your pacemaker to continually pace your heart. If your heart is beating on its own, this may result in an irregular heart rate. The intense energy created when spot welding or starting a bead may cause your pacemaker (including the pacemaker function of an implantable defibrillator) to pause temporarily if it were pacing your heart. Your implantable defibrillator could detect the electromagnetic energy from the welder (especially when spot welding) as a fast heart rhythm, causing it to deliver a shock.

SPECIFICATIONS

Model:	**MINI-MAX125**
Nominal Voltage	**230v~50 Hz**
Electrode capacity: Rutile, Basic, Stainless Steel, Cast Iron	**1.6mm - 2.5mm**
Weight	**2.8kg**
Duty Cycle 100%	**50A**
Duty Cycle 60%	**65A**
Duty Cycle 40%	**70A**
Voltage: Open Circuit (no welding being carried out)	**70v**
Voltage: Supply	**230v**

INSTALLATION

The user is responsible for the installation and use of the equipment in accordance with the manufacturers instructions.

Before installation, the user should assess the risk of electromagnetic interference on persons and the environment.

If electromagnetic interference is detected it is the user's responsibility to remedy the situation with the help of a professional electrical engineer.

This may be remedied by the introduction of filtering on the supply cable.

The welding machine should not be modified in any way and should be used only for the purpose for which it is intended.

When using the machine it is advisable to arrange cables tidily and together where possible to minimise risk of tripping.

"OSAKI POWER TOOLS *the balance of power*"

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MACHINE LABELLING

Top Labelling

The generator is a source of high frequency with rectification.

EN 60 974-1

The equipment complies with Standard EN60974-1 relating to welding machines.

The welding method is a manual arc with coated electrodes

Protection against the risk of electric shock.

The welding current is direct.

$U_o = 70V$ Vacuum voltage (with no welding being carried out) is 70V.

10A / 20V - 80A / 23,2V Potentiometer scale/current settings/conventional voltage

X	35%	60%	100%
I2	75A	65A	50A
U2	23V	22,6V	22V

X: Duty cycle is 35%, 60% & 100%

I2: Corresponding currents

U2: Live conventional voltages

Single-phase electrical feeding 50 or 60Hz..

$U_1 = 230V$ Mains feed voltage

$I_{1\,MAX} = 15,5A$ Maximum Feeding Current .

$I_{1\,eff} = 9,3A$ Current of the maximum effective feeding.

IP 21C AF Indication IP21C, protection against the penetration of solid strange bodies and vertical water falls but not under the rain

Electrical installation protection with a fuse 10A

It is obligatory to wear the UV protection helmet.

Warning! Hot sparks are produced during the welding process.

Front Labelling

Potentiometer for Setting the appropriate Current for te diameter of the selected elcetrode

Green LED for Power ON

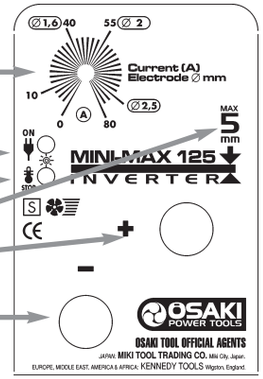
Yellow LED for Thermal Cut Out

MAX 5mm refers to the maximum thickness of metal to be welded

Positive connection for the Electrode Holder

Negative connection for the Earth Clamp

(unless specified otherwise by the elec trode manufacturer)



START-UP

Connect the machine to the mains via a 240v plug with a 10A fuse and an earth connection. Connect the current return lead (earth lead) and the electrode holder to the welder according to the polarity specified for the chosen electrode to be used.
The welder is activated by turning the potentiometer knob from “0” to the desired current for the diameter of the selected electrodes to be used.

WELDING

Be sure to observe all classical welding rules.

Leave the machine connected after welding in order to let it cool down.

Thermal protection: the yellow LED comes on when the thermal cut-out trips due to the unit overheating. The cooling down time is approx. 5 minutes, signalled when the light goes out.

The machine is equipped with the following functions;

- **HOT START**, allows a super intensity of roughly 25% on the setting;
- **ARC FORCE**, allows a super intensity of roughly 55% on the setting to avoid sticking when the electrode enters the pool; and
- **ANTI STICKING**, allows you to remove your electrode easily from the pool without it sticking.

PROBLEMS

If you are ready to weld and the machine does not produce current, please study the following possible solutions.

If both LEDs are on, wait for the cooling down period until the yellow light (thermal cut-out) switches off, reintroducing the required working current. If there is still no current,return the machine to your OSAKI distributor for repair.

If the POWER (green light) is off, check the supply connections. If none are found to be faulty, return the machine to your OSAKI distributor for repair.

If you touch the workpiece after you have finished welding and get a tingling sensation, this means that the unit is incorrectly earthed, check for faulty connections on all plugs and extensions

MAINTENANCE

Disconnect the welder and wait until the cooling fans have stopped because the internal voltage and current are high are dangerous.

Take the steel cover off regularly to inspect and clean dust from the internal components using compressed air (be sure you wear eye protection and a dust mask), making sure that the machine is no longer coneted to the mains supply